



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3278-2

Job Sheet 200332



Part No: D3278-2

Job Qty: 60 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 9/27/19

Created By: Marie Lajeunesse

Type: Stock *SOLO*

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	60 pcs	9/27/19	9/27/19	0.00	3.00	Bandsaw - 1		<i>19-09-19</i>
110	HAAS 5 Axis - B4B	60 pcs	9/27/19	9/27/19	0.06	25.75	HAAS - 5 - B4B		<i>19-09-19</i>
120	Outsource - 5 - Machining	60 pcs	9/27/19	9/27/19			MEM001-VC		<i>N/A</i>
123	Packaging 2-1 - Receive - B4B	60 pcs	9/27/19	9/27/19	0.00	0.00	Packaging 2 - 1 - B4B		<i>N/A</i>
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		



Container No: S214396



Part: D3278-2

Job No: 200332

Serial No/Batch: S214396

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 09/17/19

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				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
126	QC 6	60 pcs	9/27/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
130	QC 8	60 pcs	9/27/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47

N/A

19/09/20

140 Handfinish - 1-1 Chemical-B4B	60 pcs	9/27/19	0.00 6.18	QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 20 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
Handfinish - 1 - 16 - B4B					
Handfinish - 1 - 17 - B4B					
Handfinish - 1 - 18 - B4B					
Handfinish - 1 - 19 - B4B					
Handfinish - 1 - 20 - B4B					
Handfinish - 1 - 21 - B4B					
Handfinish - 1 - 22 - B4B					
150 Powdercoat - 1 White Gl(A)-B4B	60 pcs	9/27/19	0.00 1.23	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	60 pcs	9/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	

START: 8:15 O/T 30° FINISH: 8:45

BK 19-9-23

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						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	SFP 2 3 2019 40
						QC 3 - 19	9-89
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
	170 Packaging 3-1 - Stock - B4B	60 pcs	9/27/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	DAS
						Packaging 3 - 5 - B4B	28
						Packaging 3 - 6 - B4B	9-89
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 -	

9/10/2019

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				B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	60	9/27/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	SEP 23 2019 70
				QC 21 - SA - 53	9-89

Part Op 100 - (Bandsaw) Cut blank: 2.00" x 1.00" x 2.550" long
 Descriptions: 110 - (HAAS CNC vertical machine #5)
 123 - (Receive & Inspect for Damage & Mat'l Certs)
 126 - QC6- All purchased or subcontracted products
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	13.0200 ft (.217 ea)	100-Bandsaw - 1	3207689X49 used ALL 5195465X11 used 29"

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X02.000	13	41	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098		.100
2	Support	0.359inches ± 0.005	0.364 0.354		.359
3	Support	0.609inches ± 0.010	0.619 0.599		.610
4	Support	0.250inches ± 0.010	0.260 0.240		.250
5	Support	1.480inches ± 0.005	1.485 1.475		1.480
6	Support	0.125inches ± 0.010	0.135 0.115		.125
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115		.118
8	Support	2.439inches ± 0.010	2.449 2.429		2.440
9	Support	1.980inches ± 0.010	1.990 1.970		1.980
10	Support	0.130inches ± 0.030	0.160 0.100		.130
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257		.258
12	Support	0.375inches ± 0.010	0.385 0.365		.375
13	Support	0.875inches ± 0.010	0.885 0.865		.875
14	Support	0.500inches ± 0.010	0.510 0.490		.502
15	Support	0.400inches ± 0.010	0.410 0.390		.400
16	Support	1.000inches ± 0.030	1.030 0.970		1.000
17	Support	1.720inches ± 0.010	1.730 1.710		1.720
18	Support	0.125inches ± 0.010	0.135 0.115		.1265
19	Support	0.125inches ± 0.010	0.135 0.115		.125

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐						DEPARTMENT / PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐										
Date :	Sequence #:	QTY Affected : _____									MRB (QS042)							
Description Work Order Deviation		Disposition															Completed By	
																	Lead hand / Supervisor	
																	QC / QA Coordinator	
Root Cause		FAULT CATEGORY																
Operator ☐		Pressure/Forced Bending ☐					Contamination Misaligned/off center ☐					Power Loss/Surge Folio/Program ☐					Positioned Wrong ☐	
Manufacturing Process Equip/Tooling ☐		Crushing ☐					BOM/Route Broken/Damage/Defect ☐					Grain Direction Weld ☐					Outside Tolerance Drawing ☐	
Handling/Preservation Material ☐		Cracks ☐					Incomplete/Unclear Instructions Drill Holes ☐					Wrong Stock Pulled Out of Sequence ☐					Finish Part Lost/Missing ☐	
Product Improvement ☐		Crimp/Kink/Ripple/Wave/Twist Marks/Chatter ☐					Fit/Function ☐					Off-set/Set-up ☐					Misread ☐	
Process Improvement ☐		Other/Details:																
Human Factors ☐																		